

Date: Wednesday, 1/31/2007 2:55:24 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 30533  
 Estimate Number : 10262  
 P.O. Number : N/A  
 This Issue : 1/31/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LANDING GEAR  
 Previous Run : 30532  
 Written By :  
 Checked & Approved By : 9/07.02.01  
 Comment : Est Rev: I 02-09-25 Rearranged procedure steps KJ  
 Est Rev: J 06-03-23 As per Rev D JLM  
 Est Rev: J 06-07-13 As per dsi9343 EC

Part Number : D350636011  
 Drawing Number : D2750  
 Project Number : N/A  
 Drawing Revision : D  
 Material : N/A  
 Due Date : 2/28/2007 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 002

KS 07-03-01

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-3-Bent Extrusion (Bent) B29327 Pm 07-02-26

3.0 D2744 Fwd Cap



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Cap

Batch B27559 BE 07-02-27

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Debur end Pm 07-02-26

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only. Pm 07-02-26

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut Pm 07-02-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:55:25 PM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

Pm 07-02-26

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750

Pm/LK 07-02-26

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" wearplate holes are on bottom of tube\*\*\*\*\*

\*\*\*Make sure that

Pm/LK 07-02-26

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

Pm/LK 07-02-26

8-Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

Pm/LK 07-02-26

9-Weld D2744 Cap as per Dwg D2750 and QSI 004 Fill grooves in bend left from bending as per QSI 004

A/R

Aluminum Rod

M 102756 BE 07-02-27

10-Grind welds flush as per Dwg D2750

BE 07-03-01

11-Countersink Detail A as per dwg D2750.

BE 07-03-01

12-Scribe batch# inside per dwg D2750

Pm/M 07-02-26

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/03/05

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 7-3-2

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm 07-03-05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-03-05

W/O:		WORK ORDER CHANGES						
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2739

350 I Beam



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Web

Batch: B30497 Pm 07-03-05 ①

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Crossbolt spacer

Batch: B29981 BE 07-03-06

11.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Crossbolt spacer

Batch: B29982 BE 07-03-06

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8 Each(s)/Unit Total : 8 Each(s)

Crossbolt Spacer

Batch: B29342 BE 07-03-06

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

Pm / M 07-03-05

2-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750.

Pm / M 07-03-05

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

Pm / M 07-03-05

4-Deburr and blow out all chips from inside of tube

Pm / M 07-03-05

6-Bond web D2739 in place as per QSI 015

AVR

Sikaflex-291

batch: M163497

exp. date: 07-16-01

Pm 07-03-05 ①

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description:

(welding instructions on sheet 4)

A/R

Aluminum Rod

batch: M102756 BE 07-03-06

8-Grind welds flush as per Dwg D2750

fm 07-03-06

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

fm 07-03-06

10-Debur holes

fm 07-03-06

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/06

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/06

16.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

MR 07/03/20

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

CL 07/03/28

18.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42 Each(s)/Unit Total: 42 Each(s).

INSERT

Batch:

M103672

MR 07/03/28

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

MR 07/03/28

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

MR 07/03/28

1

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D26483

Wearpad



Comment: Qty.: 5 Each(s)/Unit Total : 5 Each(s)

Wearpad

Batch:

B29777

22.0

D265613

Wearplate



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Wearplate

Batch:

B29976

23.0

D265635

Wearplate



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Wearplate

Batch:

B29337

24.0

D2746

Wearshoe



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Wearplate

Batch:

B30141

25.0

D2745

Bushing



Comment: Qty.: 8 Each(s)/Unit Total : 8 Each(s)

Bushing

Batch:

B29437

26.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Blade Fitting LH

Batch:

B30111

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8 Each(s)/Unit Total : 8 Each(s)

PLUG ASSEMBLY

Batch:

B29044

m-h 07/03/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8 Each(s)/Unit Total : 8 Each(s)

PLUG ASSEMBLY

Batch:

B 29045

29.0

AN3C5A

Bolt



Comment: Qty.: 38 Each(s)/Unit Total : 38 Each(s)

Bolt

Batch:

M 103641

30.0

AN3C6A

BOLT



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

Bolt

Batch:

M 101418

31.0

AN3C7A

BOLT



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

BOLT

Batch:

M 102254

32.0

AN6C44A

BOLT



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

BOLT

Batch:

M 103692

33.0

AN8C35A

BOLT



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

BOLT

Batch:

M 102180

34.0

AN960C10L

washer



Comment: Qty.: 46 Each(s)/Unit Total : 46 Each(s)

washer

Batch:

M 103691

m-h 07/03/28

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C816L

WASHER



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

WASHER

Batch: M100186

36.0

MS210436

NUT



Comment: Qty.: 4 Each(s)/Unit Total : 4 Each(s)

NUT

Batch: M102532

37.0

MS21083C8

NUT



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

NUT

Batch: M103492

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46 Each(s)/Unit Total : 46 Each(s)

WASHER

Batch: M103641

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10 Each(s)/Unit Total : 10 Each(s)

WASHER

Batch: M102515

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M103581

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M103447

EXP DATE: 07/10

①

m-A  
07/03/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Coat all exposed fasteners with "LPS Procyon"

batch:

M17168

m-l 07/03/28 ①

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.03.30 ①

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

SAN 07/04/07 ①

43.0

D2741

Blade



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Blade

Batch: 1329868 ✓

44.0

AN960C816L

WASHER



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Washer

Batch: M100186 ✓

45.0

MS21083C8

NUT



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Nut

Batch: 100186 ✓

46.0

AN8C21A

BOLT



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Bolt

Batch: 103547 ✓

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

WASHER

Batch: M102515 ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 2 Date: 07/05/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 30533

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

D34931

WASHER



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

WASHER

Batch: B29798 ✓

49.0

D35321

spacer



Comment: Qty.: 2 (s)/Unit Total : 2 (s)

batch: B27894 ✓

SAD 02/04/02 (D)

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

✓ 02/4/2 (GSD)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

02/4/2

02/04/02

SD

52.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

02/04/05

Job Completion



u 02/04/04

B30533

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**DART****RELEASED**  
06-02-07

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30533

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DEPARTMENT OF  
COMMERCE  
WASHINGTON  
D. C.



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

RELEASED  
660207

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ - $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

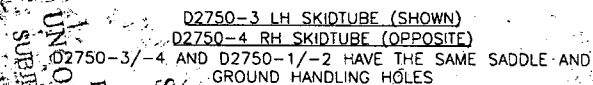
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
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02.02.07 #



NO. 2005-33

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DATE 06.01.05		TITLE 350 SKIDTUBE, ASSEMBLY SCALE 1:20			

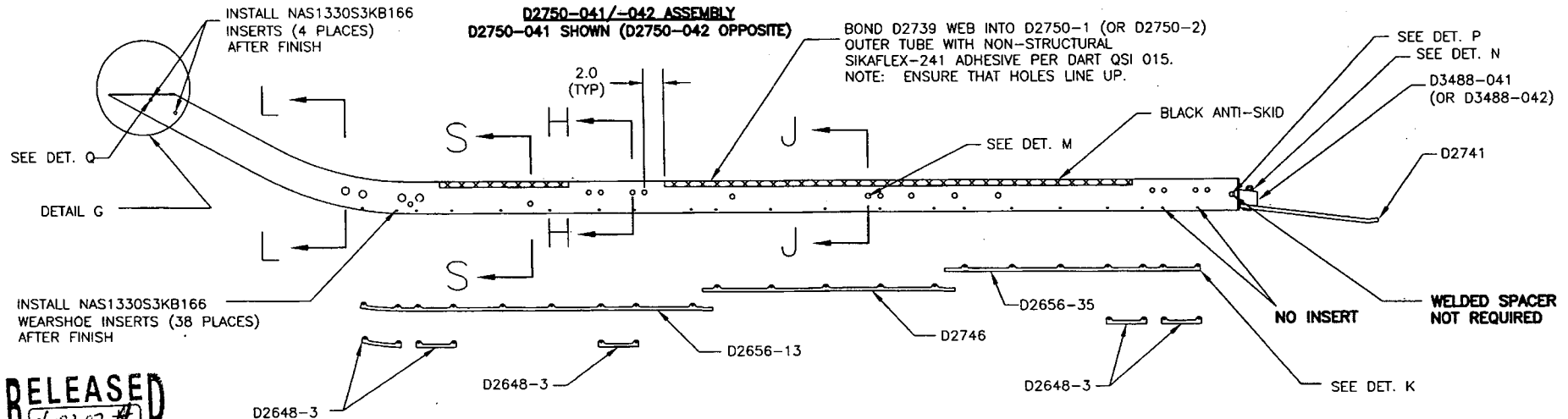


Handwritten notes and scribbles are visible in the lower right quadrant of the page, spanning across the vertical line. The text is extremely faint and illegible, appearing as light gray marks on the white background. Some faint, larger characters are visible, possibly including "100" and "1000", but they cannot be definitively transcribed.



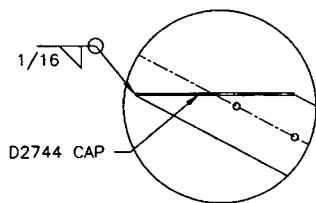
**D2750-041/-042 ASSEMBLY**  
**D2750-041 SHOWN (D2750-042 OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
 OUTER TUBE WITH NON-STRUCTURAL  
 SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
 NOTE: ENSURE THAT HOLES LINE UP.



**RELEASED**  
 06-02-07 #

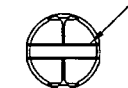
**DETAIL G**



**SECTION H-H** D2743 SPACER (REF)



**SECTION J-J**



**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

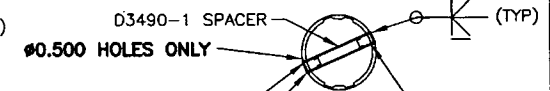
**SECTION L-L**



Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

**SECTION S-S**



Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

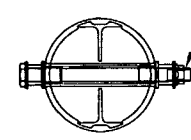
**DETAIL K**



USE AN3C7A BOLTS  
 FOR INSTALLING AFT  
 D2648-3 WEARPAD  
 (4 PLACES)

AN3C5A BOLT (1)  
 AN960JD10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (38 PLACES)

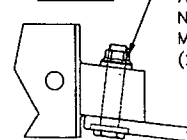
**DETAIL M**



AN6-44A BOLT (1)  
 D2745 BUSHING (2)  
 NAS1515H8L WASHER (2)  
 MS21043-6 NUT (1)  
 (4 PLACES)

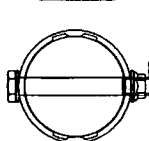
NOTE: INSTALL WASHER BETWEEN  
 SKIDTUBE AND BUSHING

**DETAIL N**



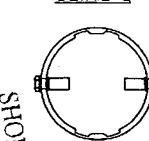
AN8C21A BOLT (1)  
 AN960JD816L WASHER (1)  
 NAS1515H8L WASHER (1)  
 MS21083C8 NUT (1)  
 (2 PLACES)

**DETAIL P**



AN8C35A BOLT (1)  
 AN960C816L WASHER (2)  
 NAS1515H8L WASHER (2)  
 MS21083C8 NUT (1)

**DETAIL Q**



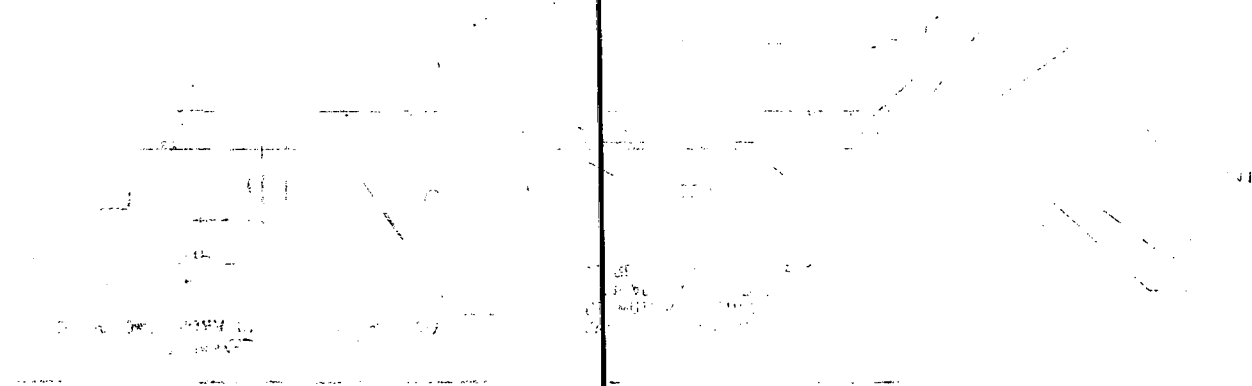
AN3C6A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (4 PLACES)

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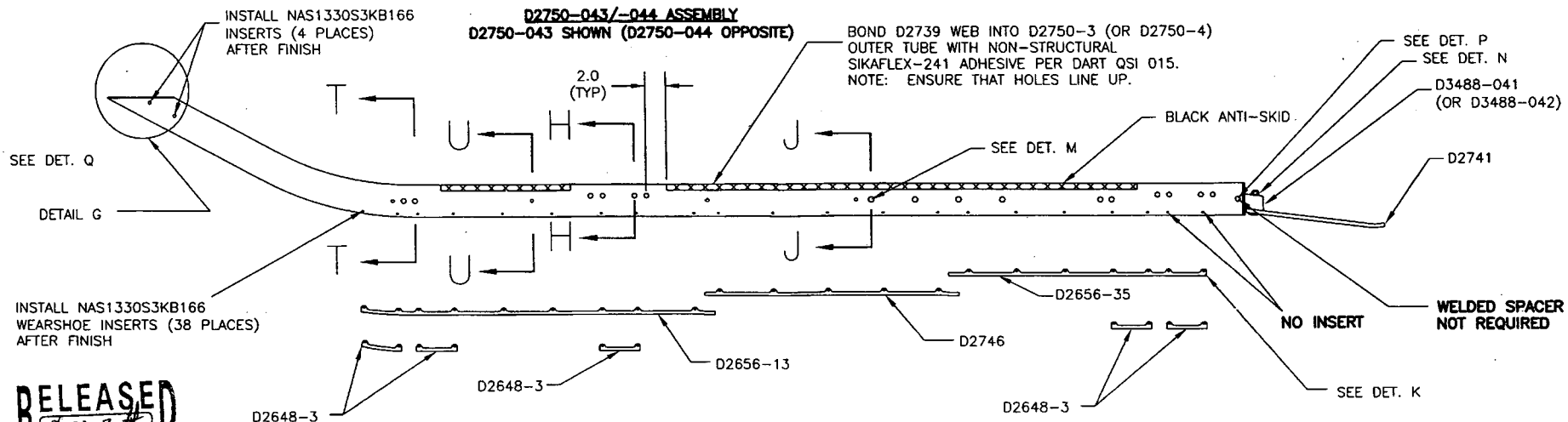
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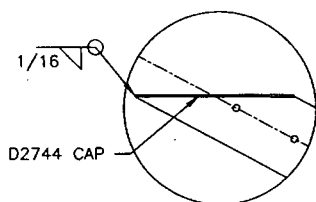
**D2750-043/-044 ASSEMBLY**  
**D2750-043 SHOWN (D2750-044 OPPOSITE)**

BOND D2739 WEB INTO D2750-3 (OR D2750-4)  
 OUTER TUBE WITH NON-STRUCTURAL  
 SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
 NOTE: ENSURE THAT HOLES LINE UP.

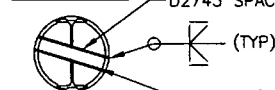


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 06-01-07

**DETAIL G**



**SECTION H-H**



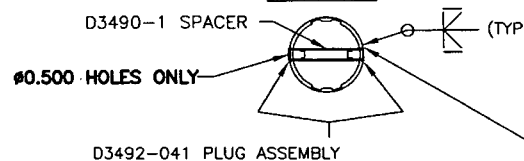
**SECTION J-J**



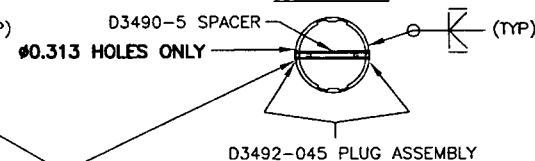
**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

**SECTION T-T**



**SECTION U-U**



**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

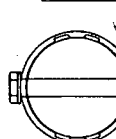
**DETAIL K**



USE AN3C7A BOLTS  
 FOR INSTALLING AFT  
 D2648-3 WEARPAD  
 (4 PLACES)

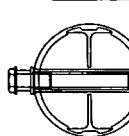
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 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (38 PLACES)

**DETAIL P**



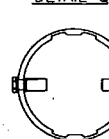
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 AN960C10L WASHER (2)  
 NAS1515H8L WASHER (2)  
 MS21083C8 NUT (1)

**DETAIL M**



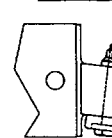
AN6C44A BOLT (1)  
 D2745 BUSHING (2)  
 NAS1515H8L WASHER (2)  
 MS21043-6 NUT (1)  
 (4 PLACES)  
 NOTE: INSTALL WASHER BETWEEN  
 SKIDTUBE AND BUSHING

**DETAIL Q**



AN3C6A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (4 PLACES)

**DETAIL N**



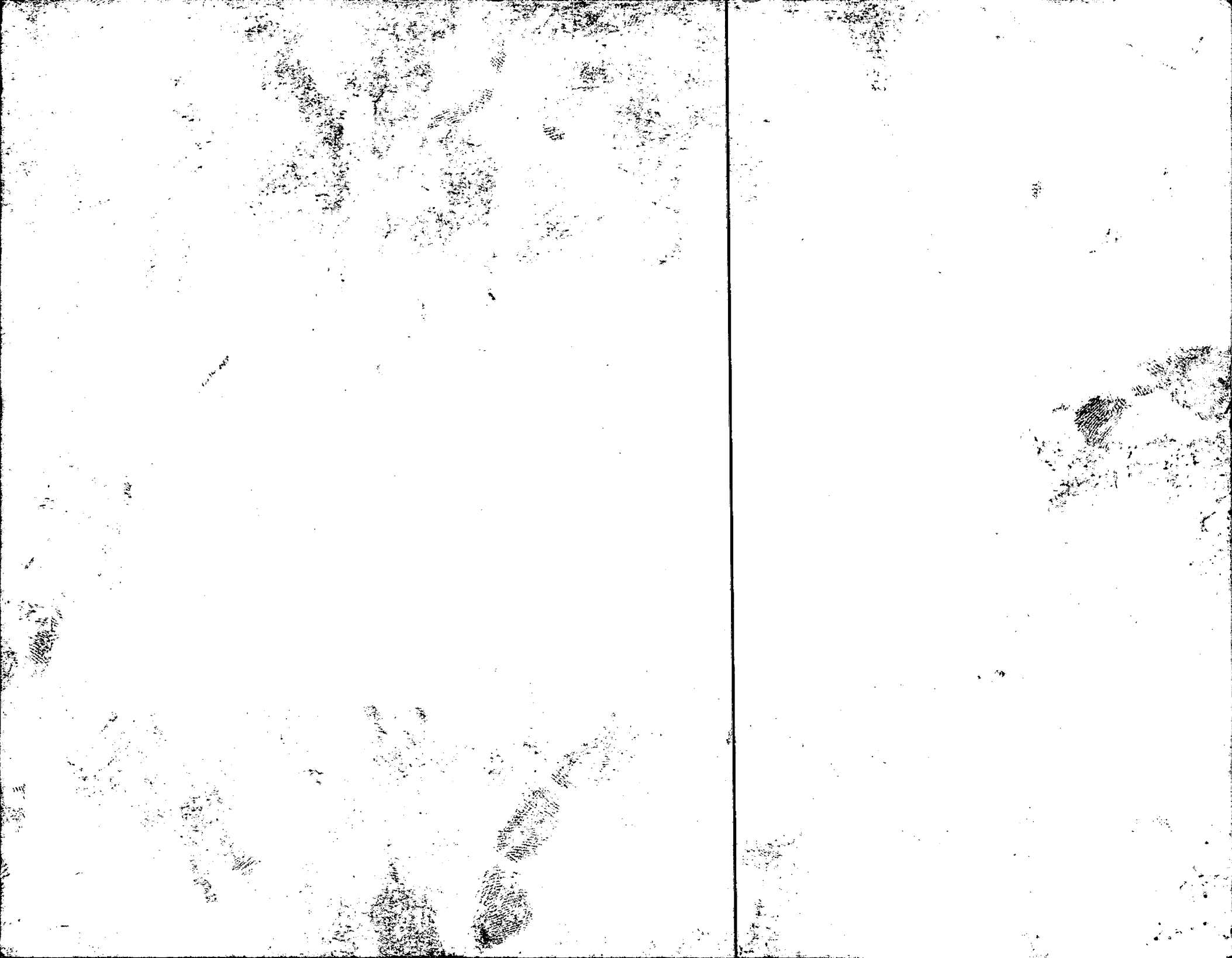
AN8C21A BOLT (1)  
 AN960JD816L WASHER (1)  
 NAS1515H8L WASHER (1)  
 MS21083C8 NUT (1)  
 (2 PLACES)

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NO. 96

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number D350636013 / B30120

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/05 Qualifier David Haval